



explanation of valve configuration at each stage Press operation in standard sequence with brief

2) With the press cycle now started-the hydraulic pump will DPress cycle begins when pushing "close press" button on PLC. continue cycling to maintain 3,000 psi during each stage. At indicator light-allowing operator to activate the "press start" any time, psi falls below 3,000 psi-press ops will abort. When psi is obtained-PLC will alluminate "press closed" piston forward until clamping weight reaches 3,000 psi. This will activate hydraulic pump (shown orange) moving

> (press effluent) Filtrate tank

Sludge Feed

Tank

V-2 and V-3. {V-4 & V-5 remain closed for a time of 2 At this time "V-1" (press feed valve) will open along with

 With press in "Timed" mode, press will continue until preset (stage 1) time elapses (15 min.) minutes, allowing press to fill evenly throughout) At elapse of preset time- "V-4 & V-5" will open

Returned to Industrial plant

Bldg. 141

From Industrial Plant

Bldg. 141

4) At this point the PLC signals ACV-1 to increase air pressure to 50 psi for a preset time as indicated by stage 2

5) With time elasped for stage 2, the PLC will again increase air pressure to pump "A" to 100 psi 6) When stage 4 is reached, "V-11 closes and "V"-10 opens sending the same 100psi to feed and operate at this rate for the programed amount of time in stage 3

pump "B" which is a high pressure diaphragm pump & excerts double the pressure into the "IIMED" mode will continue until prelapes time is obtained. press. Converting a 100psi into 200psi which constitutes stage 4. Again with the press in

 When stage 4 is complete, the program calls for press to enter a "Core blow" mode. This final usally takes 2-5 minutes and avoids excess sludge drainage when opening press. part of the operation signals for SV-14 (Solenoid Valve) to open position enabling a max. of 100 psi into upper left filtrate line, forcing remaining sludge back thru . "V-1". This process

V-1. At the conclusion of this stage all valves will close & "PRESS COMPLETE" appears in PLC screen When press enters the Core Blow stage V-2,3,4 & 5 are signaled to close-allowing "blow back" only through time that press is at maximum load the stroke of the feed pumps which indicates by the "stall" movement through air supply line. This lack of air the PLC. This device is programmable and signals the PLC movement translates the amount of time or space between when a preset time (3 to 5 seconds) elapses between air



flow mode a AUTOMATIC AIR FLOW SWITCH (AFS-1) is installed on the main air supply line and is monitored by

mode. (as opposed to "TIME mode) The difference being in The 2 JWI presses have capability to operated in "FLOW"

